

Monday, 11/05/2009 1:22:37 PM
Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Drawing Name : ARM
 Job Number : 47865 -2
 Estimate Number : 12883
 Part Number : D3560043
 Order Number :
 Drawing Number : D3560 REV D
 Issue Date : 11/05/2009 S.O. No. :
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 28/05/2009 Qty: *split 3* Um: Each
 Previous Run : 46619
 Type : MACHINED PARTS
 Written By :
 Checked & Approved By : *11/05/09*
 Comment :
 Est Rev: A New Issue 07.05.24 EC
 Est Rev B ECN 987 07.10.09 EC
 Est Rev C ECN1048 07-12-18 DD verified by: EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00



Comment: Qty.: 1.3598 f(s)/Unit Total: 5.4390 f(s)
 6061-T6 Bar 0.50" x 5.00"
 Batch: *M111408*

mk 09/05/20

(4)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 15.500" long

mk 09/05/20

(4)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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(4)

Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: D & Dwg D3560 Rev: D

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

BA 09/05/23

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



(4)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BA

09/05/23

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 47865

Part Number: D3560043

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ink 09/05/28

(4)

6.0 D35921 Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
PLATE *B 46891*

PK 09-06-09 3

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad) *PK*
- 2- set up bracket and arm on jig *PK*
- 3- preheat bracket and arm with torch *PK*
- 4- clean before welding with brush *PK*
- 5- set up machine to 135 amps *PK*
- 6- weld across bottom and top ends *PK*
- 7- reheat with torch (65 deg C) *PK*
- 8- on one side weld from bottom to top half way *PK*
- 9- same for other side (half way) *PK*
- 10- from half way point weld the rest of the first side (ease off pedal near end) *PK*
- 11- same for remaining side (ease off pedal near end) *PK*

PK 09-06-09 3

8.0 QC5 INSPECT WORK TO CURRENT STEP



(2043)

Comment: INSPECT WORK TO CURRENT STEP

S 09/06/09

(43)

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PK 09-06-09 (3)

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

PK 09-06-10 (3)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 47865

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-06-10

X3

12.0

D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

batch:

342181

09/06/11

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

09/06/11

3

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/11

043

X3

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

W19

09-06-11

3

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/11

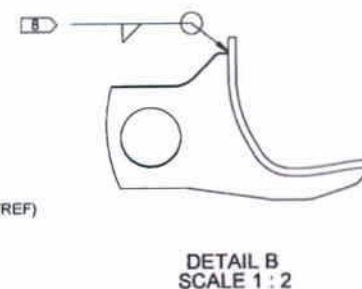
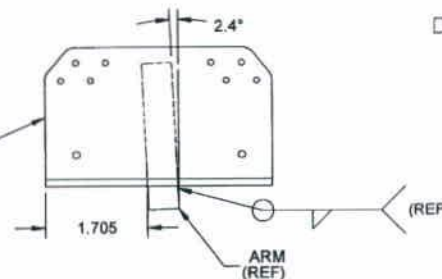
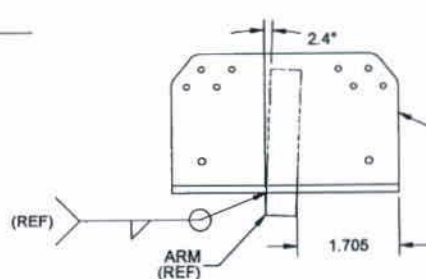
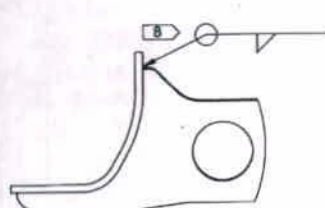
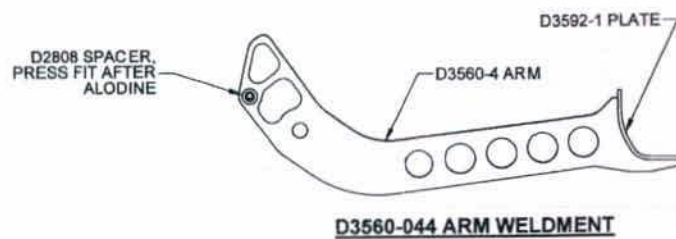
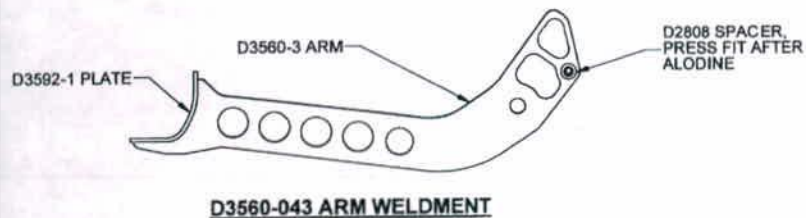
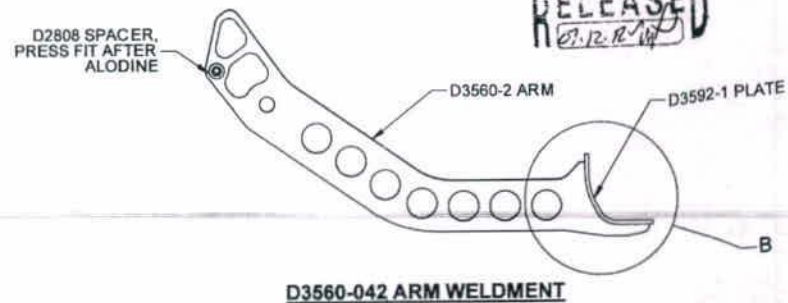
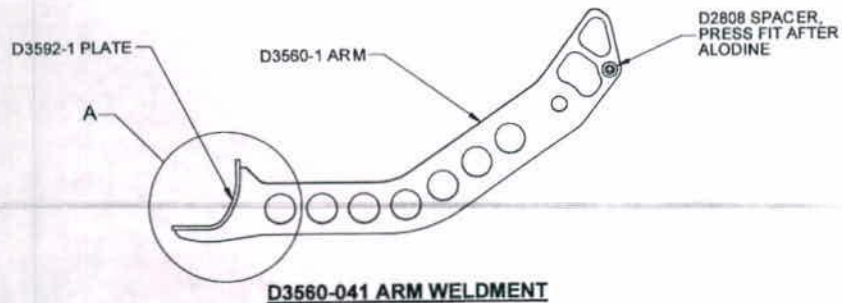
NF

09-06-11

Job Completion



RELEASED
07.12.16



PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

DESIGN	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
DRAWN	REMOVE POWDER COAT	CP	07.08.19
CHECKED	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
MFG. APPR.	NEW ISSUE	CP	06.09.25
APPROVED		BY	DATE
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3560	REV. D
TITLE ARM WELDMENT	SHEET 1 OF 5
SCALE 1:4	

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NO 17865

WORK ORDER

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DETAIL A
SCALE 1:2

1) MATERIAL: N/A

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

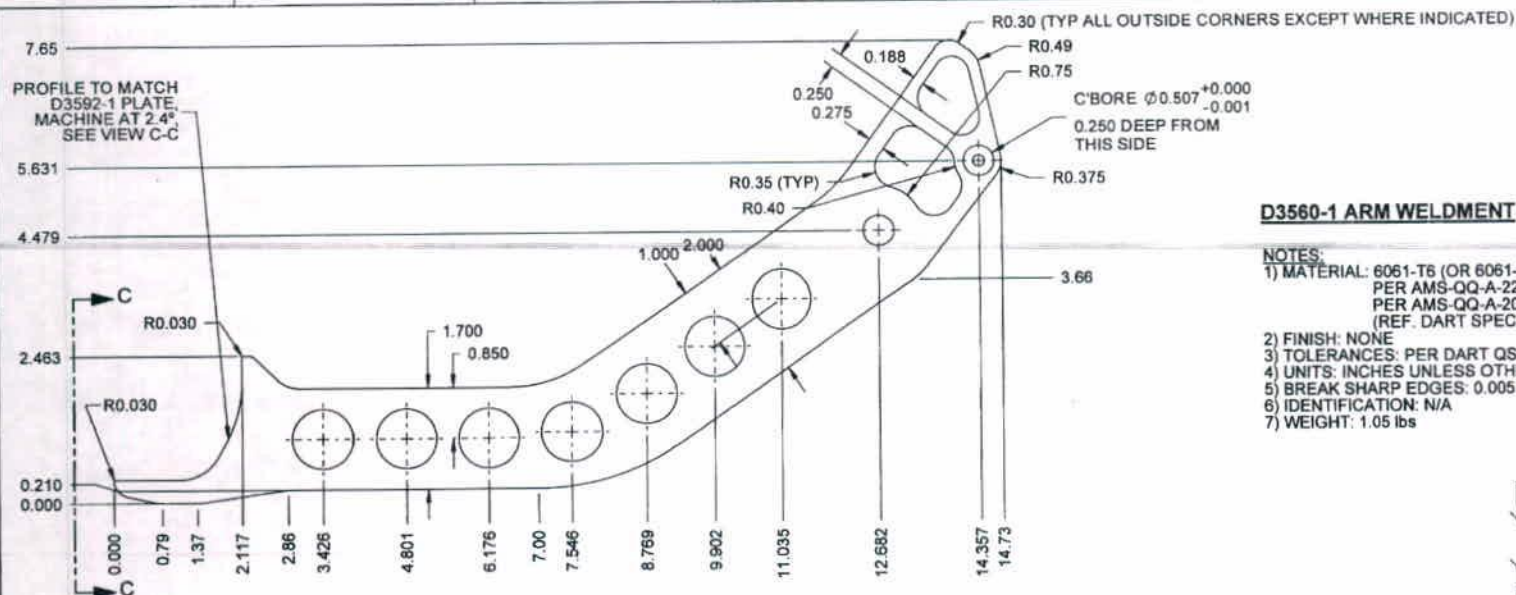
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 1.23 lbs (TYP)

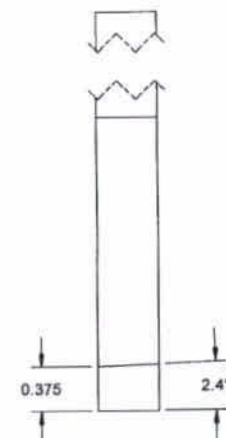
8) WELDING: PER DART QSI 004

PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4°
SEE VIEW C-C



D3560-1 ARM WELDMENT

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs

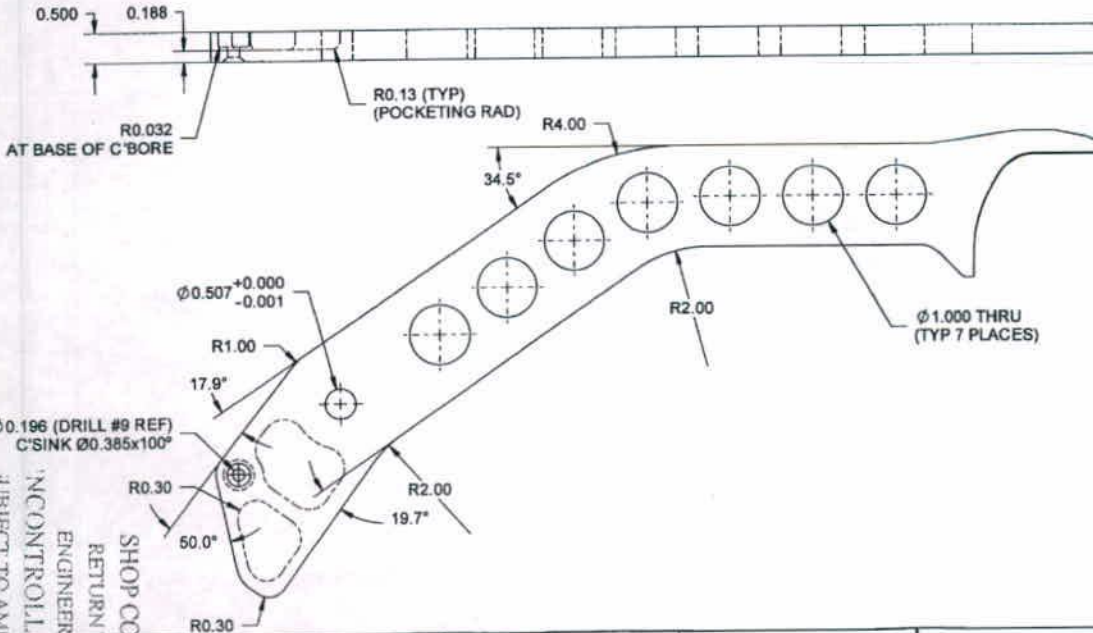
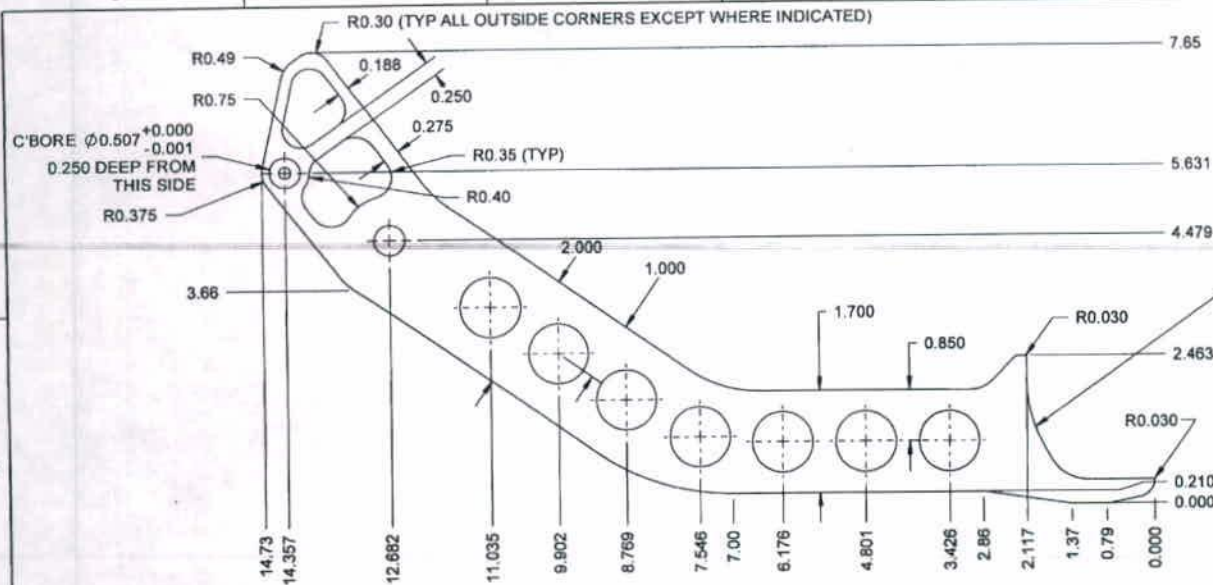


VIEW C-C
SCALE 1:1

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MFG. APPR.		D3560	SHEET 2 OF 5
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DE APPR.		ARM WELDMENT	12
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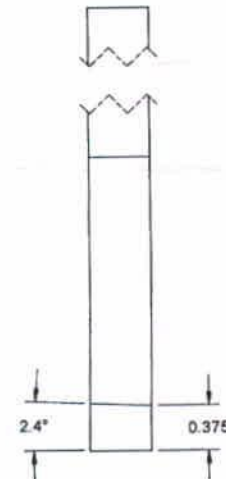


PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4°,
SEE VIEW D-D

D3560-2 ARM

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW D-D
SCALE 1:1

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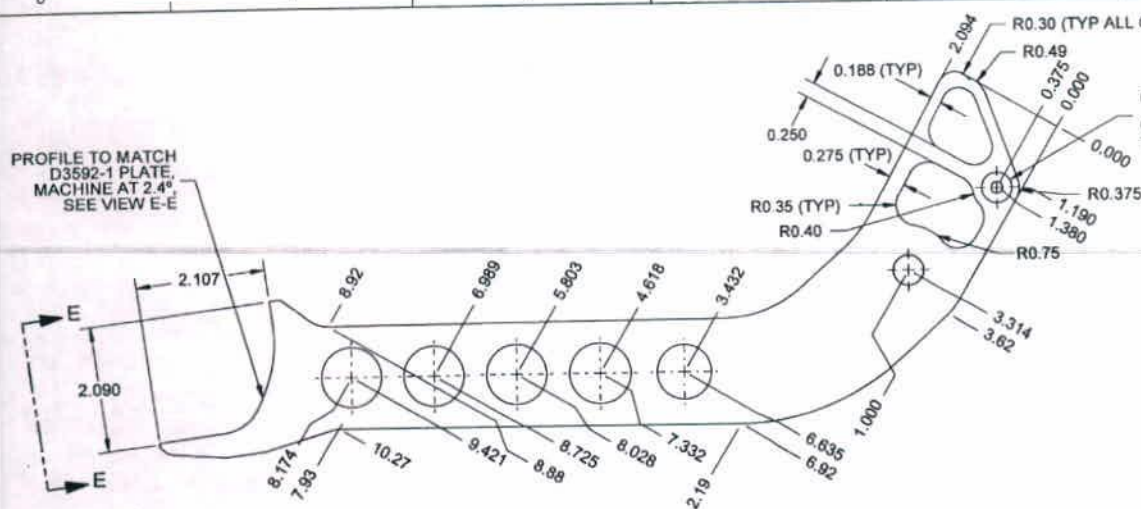
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	REV. D
D3560	SHEET 3 OF 5
TITLE	SCALE
ARM WELDMENT	1:2

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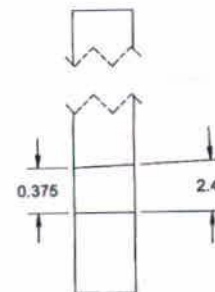
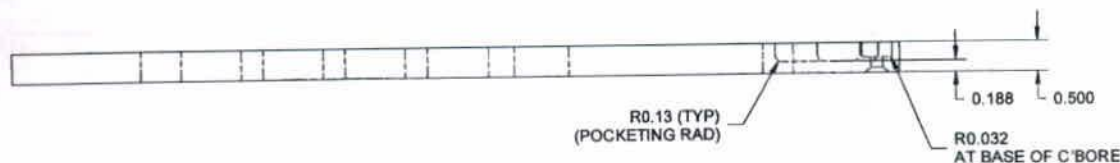
PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4°
SEE VIEW E-E



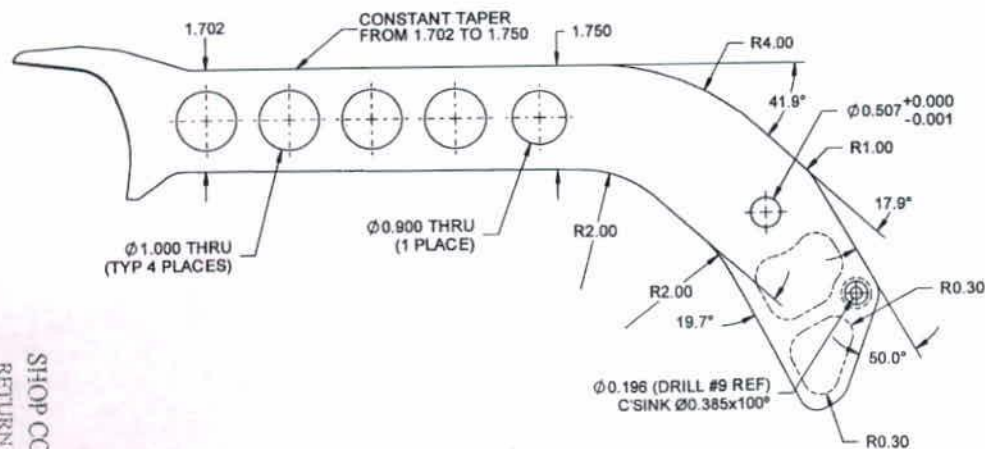
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-226/B (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/B (OR AMS 4180)
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

D3560-3 ARM



VIEW E-E
SCALE 1:1

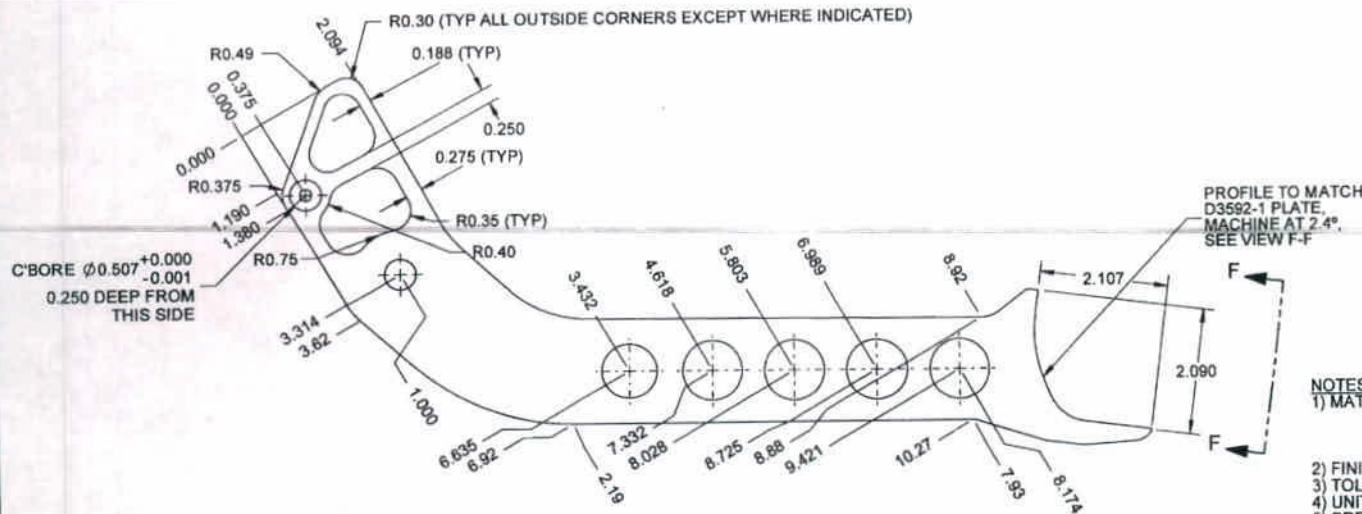


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DATE	07.11.16

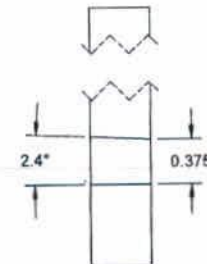
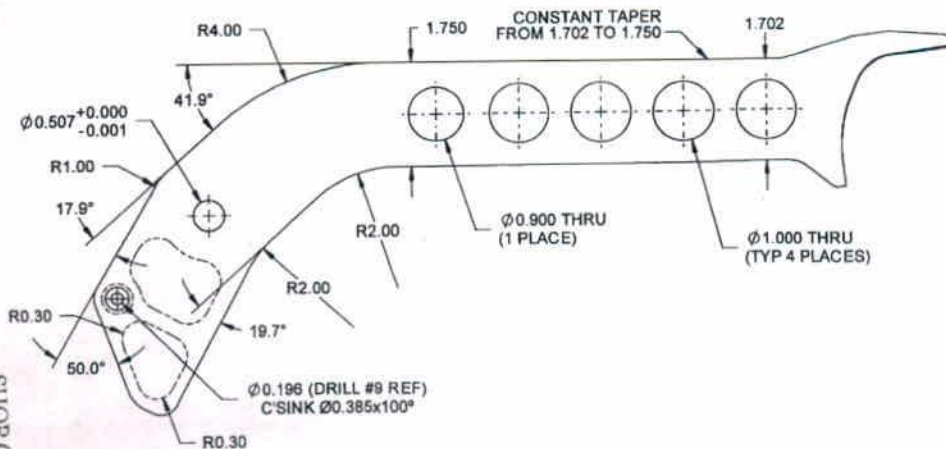
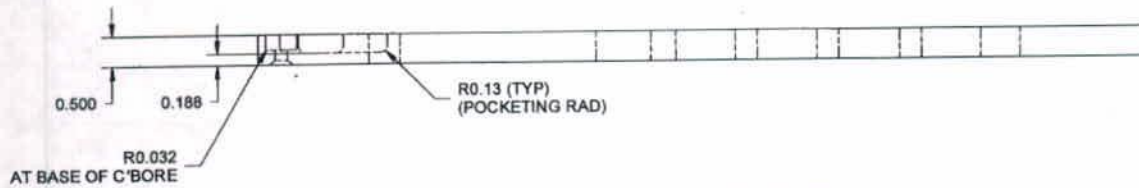
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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TITLE ARM WELDMENT	SHEET 4 OF 5
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D3560-4 ARM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.05 lbs



VIEW F-F
SCALE 1:1

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MFG. APPR.		D3560	SHEET 5 OF 5
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DE APPR.		ARM WELDMENT	1:2
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